04092-042 Work Order ID 109451 Page 1 B109451 November-21-13 2:28:07 PM Item ID: D4092-042 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Maintenance Step Assembly \*2\* Start Oty: 2.00 **Start Date:** 11/21/13 **Cust Item ID:** Required Date: 11/21/13 Reg'd Oty: 2.00 Customer: Reference: Run Process Plan: MLJ Date: 13-11-25 Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Insp. Accept Work Center ID Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D4092 В Pick Kit 0.00 \*100\* 0.00 Packaging Memo Packaging 0.00 \*110\* Small Fab 0.00 Memo Small Fab Assemble as per Dwg Torque screws up to 15-25 in- lbs QC5- Inspect part completeness to step on W/O 120 \*120\* Memo

Quality Control

DQA: Date:						$^{\prime\prime}$ Jart									
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QA Closed:			Date:		1						VVC	ork Order up	date only		
Work Orde	r:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	-					Rework			Skid-tube	Crosstube			Water Jet	Engineering	
Part N	lo.					Scrap		Machining Small Fab					d. Eng. Coor.	Quality	
	_					Use-as-is		Thermoforming Finishing				Rec/Stor	re/Packaging	Other	
NCR N	ю.					Suspected Unapproved	ا ا	Large Fab Composite					Supplier	ا لـا ·	
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	Cracks				Broken/Damage/Defect		Hardwa				Part Incorred	·	Temperature/Cure		
		Crimp/Kin	k/Ripple	/Wave	<u> </u>	Burrs	<u> </u>	1	ion Incomplete/U	•		Part Lost/Mi	_	Weld	
	Cuffs			<u> </u>	Contamination		4	tions Incomplete/			Part Moved	Lun	Wrong Stock Pulled		
Crushing				Countersink	<u></u>	1 7	gned/off center			Positioned V		٦			
Heat Treat			<u> </u>	Cut Too Short	<u> </u>	Mislabe				Power Loss/	Surge	Other			
		Inspection		Tube	-	Drawing	$\vdash$	Misrea							
		Marks/Ch			$\vdash$	Drill Holes	Off-set								
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Wave/Twist in Tube			e e		Fit/Function	1	Out of Sequence								

Work Order ID 1	109451
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Page 2

Insp.

November-21-13 2:28:07 PM \*N900040100\* Item ID: D4092-042 Accept Setup Start **Revision ID:** Stop Maintenance Step Assembly Item Name: Start Qty: 2.00 Start Date: 11/21/13 **Cust Item ID:** Required Date: 11/21/13 Req'd Qty: 2.00 **Customer:** Reference: Run Process Plan: \_\_\_\_ Date: **Tooling:** Date: Approvals: Stop Date: \_\_\_\_\_ SPC (Y/N): Date: QC: Sequence ID/ Operation Tool ID Tool # Plan Reject Set Up/ Accept Reject Work Center ID Number Stamp Qty Qty **Description Run Hours** Code Identify as per dwg & Stock Location:\_ 0.00 130

140

QC21- Final Inspection - Work Order Release

0.00

0.00

\*140\* QC

\*130\* Packaging

Packaging

Memo

0.00

Quality Control

DQA:			Date:		•										
						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:		:	Date:							W	ork Order up	date only			
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS	·		
	-	<del>i</del>				Rework			Skid-tube Crosstube			Water Jet	Engineering		
Part N	lo.					Scrap		1	Machining Small Fab		Prod	d. Eng. Coor.	Quality		
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ļ	1	Wave/Tw	vist in Tub	oe e	1	Fit/Function		Out of	Sequence						

## **Picklist Print**

November-21-13 2:28:06 PM

Work Order ID:

109451

Parent Item:

D4092-042

Parent Item Name:

Maintenance Step Assembly

**Start Date:** 11/21/13

Required Date: 11/21/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED:DD

IPP REV:B AS PER ECN 11-

Comments:	639 JLM VERIFIE		LM VE	KIFIED:DD	IP.	P REV:B AS F	EK ECN I	1-					
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status DAS
D4092-1 Maintenance Step		Manufactured	No				Each	9.0000		4	13	11/20	36 989
				Location		Loc Qty	Le	oc Code		,			ż
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;					852	1						//	DAS
D4093-1 Bracket		Manufactured	No				Each	12.0000	·	2	13/	11/20	DAS 36 9-89
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D4093-5		Manufactured	No.				Each	8.0000		4	1	3/11	LJC 9-8
Bracket				<u>Location</u>		Loc Qty	1.	oc Códe				77	
				ST092		<u> </u>	<u> </u>	oc couc				•	
,		·			08405	8					_	/ /	
<b>MS24694-S54</b> SCREW	,	Purchased	No				Each	416.0000		4	[3	1/1/2	DAS 36
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	•					Rework		,	Skid-tube Crosstube	e 🗌	]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fal	∘匚	4	d. Eng. Coor.	Quality
						Use-as-is		Therr	noforming Finishing	_	Rec/Sto	re/Packaging	Other
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Picklist Print
November-21-13 2:28:07 PM

Work Order ID: Parent Item:	109451 D4092-042						e: 11/21/13	Required Date: 11/21/13	3
Parent Item Name:	Maintenance Step Assembly					Start Qt	y: 2.00	Required Qty: 2.00	- 10
MS24694-S55 Screw	Purchased	No			Each	225.0000	10	5 13/1/26	DAS 36 9-89
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			121340	10					
			125535	15			4		DAS
			m126400	100				//	36 9-89
NAS1149D0332J Washer	Purchased	No		•	Each	2,830.0000	24	13/1/26	9-89
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			m127374	520			24		
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			ST294	306					
			122973	75					
			125044	. 8					
:			m125807	223		•	<u> </u>	A.	•
			ST511	1000					
수 호			m127389	1000					

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						WORK ORDER NON-	-CC	ONFO	RMANCE / UPI	DATE			AEROSPACE
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	-					Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	۱o.	"ii				Suspected Unapproved			Large Fab	Composite		Supplier	
Root	Ī				Desci	ription of work order update	ı	Initial	Actio	n	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector
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		Cracks				Broken/Damage/Defect	<u></u>	Hardwa		_	Part Incorre	<b></b>	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unq	ualified	Part Lost/Mi	issing	Weld
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	L	Heat Trea				Cut Too Short		Mislab			Power Loss/	Surge	Other
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	_	Marks/Ch				Drill Holes	$\vdash$	Off-set	*				
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1		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

November-21-13 2:28:07 PM

Work Order ID:

109451

Parent Item:

D4092-042

Parent Item Name:

Maintenance Step Assembly

MS21042L3

Nut!

Purchased

No

**Start Date:** 11/21/13

Start Qty: 2.00

Required Date: 11/21/13

Required Qty: 2.00,

24

DAS

26 9-89

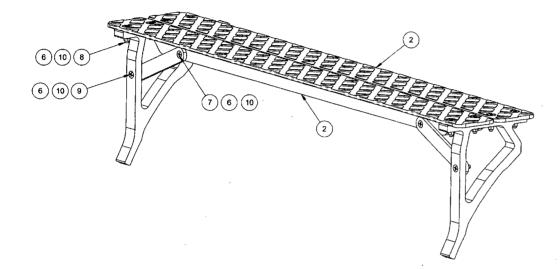
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M126036	35				
M127304	1000				
ST506	814				
123900	814				
ST509	3000				
M127410	3000				
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QA Closed:			Date:			WORK ORDER NON-	-((	JINFOI	RIVIANCE / UPDAT		ork Order up	date only	AEROSPACE
Work Order		1		<del></del>		DISPOSITION			AG	AINST DE	PARTMENT,	PROCESS	
Part No.  NCR No.				Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Prod Rec/Stor	Engineering Quality Other			
Root	T				Desci	ription of work order update		nitial	Action		Sign &	<u></u>	
Cause	D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved		:		•									
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	_	-	equence st in Tub		-	Finish Fit/Function	-	4	Calibration Sequence				

			'
ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	Х	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

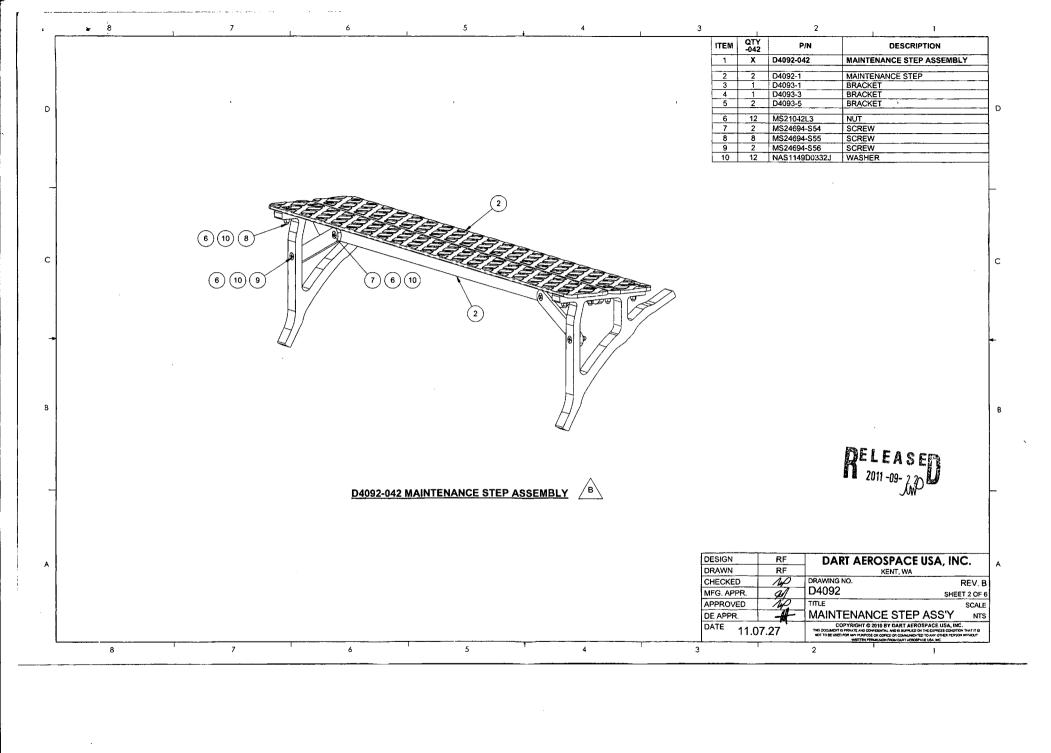


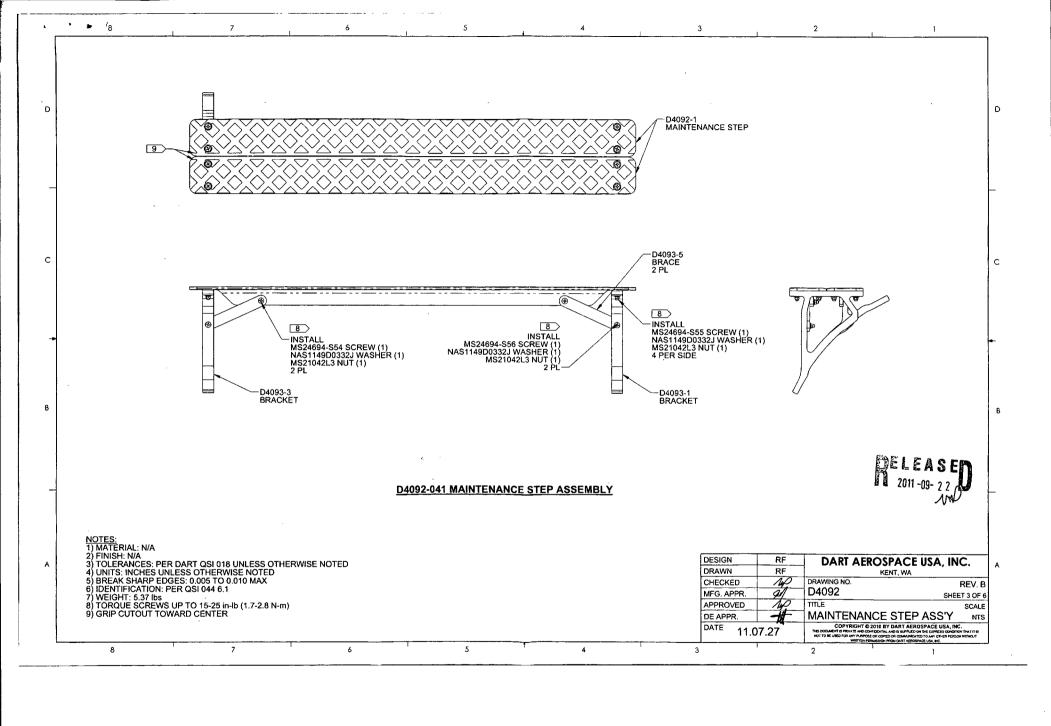
109451 MLJ 13-11-25

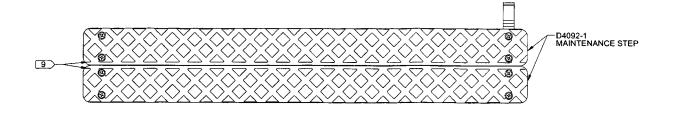
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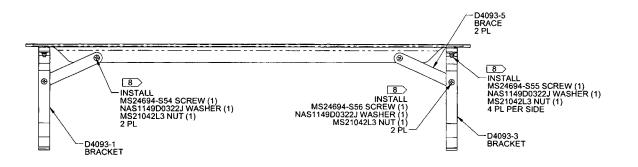
D4092-041 MAINTENANCE STEP ASSEMBLY

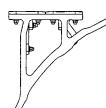
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В	REDRA	NN; LOWERED	FOR AESTHETICS	RF	11.07.27			
Α	NEW IS	SUE		RF	10.09.16			
REV.			DESCRIPTION	BY	DATE			
DESIGN	1	RF	DART AEROSPACE	AZII	INC			
DRAWN	1	RF	KENT, WA					
CHECK	ED	140	DRAWING NO.		REV. B			
MFG. A	PPR.	91	D4092		SHEET 1 OF 6			
APPRO	VED	148	TITLE		SCALE			
DE APP	R.	#	MAINTENANCE STEP	ASS	'Y NTS			
DATE	11.0	7.27	THE DOCUMENT & PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONSTRUCT THE NOT TO BE USED FOR ANY PRIVATED BY CONFIDENCE AND TO ANY EXPRESS CONSTRUCT TO ANY OTHER PERSON WITHOUT TO BE USED FOR ANY PRIVATED BY CONFIDENCE ON COMMANDED TO ANY OTHER PERSON WITHOUT TO BE USED FOR ANY PRIVATED BY CONFIDENCE ON COMMANDED TO ANY OTHER PERSON WITHOUT THE PERSON WITH THE PERSON WITH THE PERSON WITH THE PERSON WITH THE PERSON WI					











## **D4092-042 MAINTENANCE STEP ASSEMBLY**

- NOTES:
  1) MATERIAL: N/A
  2) FINISH: N/A
  2) FINISH: N/A
  3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  4) UNITS: INCHES UNLESS OTHERWISE NOTED
  5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  6) IDENTIFICATION: PER QSI 044 6.1
  7) WEIGHT: 5.37 lbs
  8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
  9) GRIP CUTOUT TOWARD CENTER

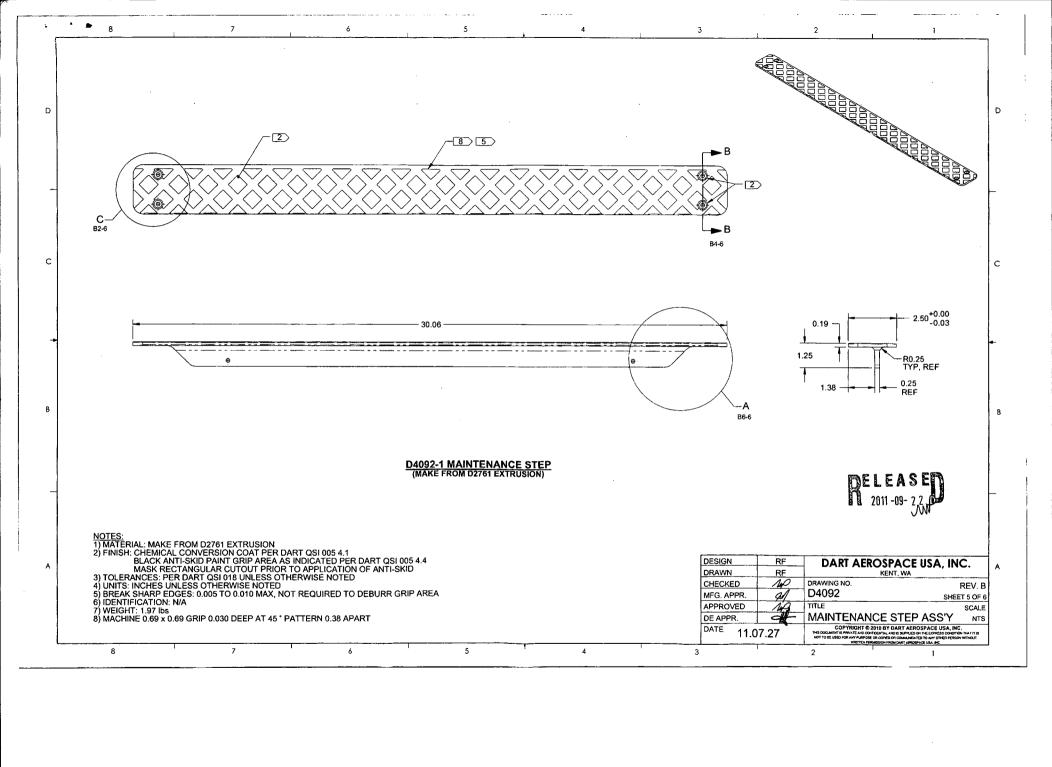
DESIGN	RF	DART AEROSPACE U	SA. INC.
DRAWN	RF	KENT, WA	
CHECKED	NP	DRAWING NO.	REV. B
MFG. APPR.	91	D4092	SHEET 4 OF 6
APPROVED	142	TITLE	SCALE
DE APPR.	-#	MAINTENANCE STEP A	SS'Y NTS

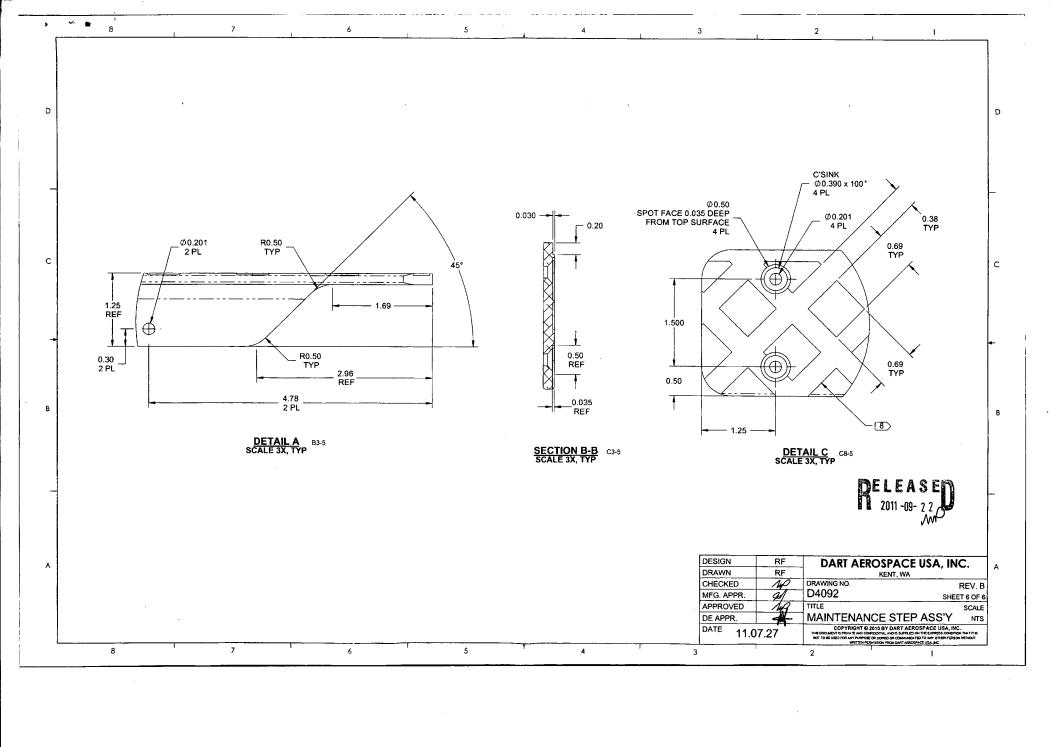
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